Nylon Gel Spinning:	_		_	
RXT-2 UNIT			·	
CHANGE NUMBERS WHERE IT IS BLUE COLOR				
MINIMUM PUMP RPM	80			
MAXIMUM PUMP RPM	40			
PUMP SIZE(CC/REV.)	1.16			
NUMBER OF FILAMENTS	14			
PUMP SPEED(RPM)	19.7			
POLYMER DENSITY(GM/CC)	0.98			
THRU-PUT(LBS/HR)	2.95969		<u> </u>	
THRU-PUT PER FIL(LBS/HR)	0.21141	0.21141 THRU-PUT PER FIL(GMS/MIN)	1.5982	
THRU-PUT(GMS/MIN)	22.395	22.395 THRU-PUT(GMS/MIN)	22.395	
THRU-PUT PER FIL(GMS/MIN)	1.59964			
TAKE-UP SPEED (Meter/min)	3000	FROM FTMIN TO MMIN	0.3048	
DPF GMS @TAKE-UP ROLL (UNDRAWN)	4.79892		7.	
DTEX PER FIL GMS @TAKE-UP ROLL (UNDRAWN)	5.33213			
FIL DIAMETER, MICRONS (UNDRAWN)	22.1859		22.186	
FIL DIAMETER, mm (UNDRAWN)	0.02219			
TAKE-UP SPEED (FEET/min)	9842.52			
Spinnerette	diameter	length	5	AREA
INCH	0.03	0.09	3	0.0007065
СМ	0.0762	0.2286	6	0.00455806
YARN DENIER @TAKE-UP ROLL (GMS)	67.1849			
FLOW RATE(CC/MIN)	22.852			
JET VELOCITY (CM/MIN)	5013.54		<u></u>	
JET VELOCITY (meter/MIN)	50.1354	50.1354 DR @ (TAKE-UP ROLL)		59.8379407
SPIN. CAPILLARY RADIUS (FT)	0.0025			
SPIN. CAPILLARY LENGTH (FT)	0.0075			
THRU-PUT PER FIL(LBm/HR)	0.21141			
DENSITY(LBm/FT3)	61.1814			
FLOW RATE(FT3/SEC.)	9.6E-07			
VISCOSITY (POISE)	3143.9			
VISCOSITY (LBf.SEC/FT2)	6.56634			
DELTA PRESSURE(PSI)	21.4101			
Stack Draw (calc. From sprt hole dia. And fil dia.)	34.3462			
FINAL REQUIRE DENIER AFTER DRAWIN	10			
DRAWING DRAW RATIO	0.47989			
			-	

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Sample I.D.	Conditions	#	2	8	#	\$	\$2	#	82
				MBM 10%	MBM 10%	MSM 10%	MBM 10%	MBM 10%	MBM 10%
POLYMER TYPE	MBM	MBM		Lactam	Lactam	Lactam	Lactam	Lactam	Lactam
Feeder Setting	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96
Date	10/23/02	10/23/02	10/23/02	10/23/02	10/23/02	10/23/02	10/23/02	10/23/02	anzant.
water on feeding zone	8	uo	5	5	ક	S	G	8	5
zone 1 Temp. (deg c)	245	270	250	250	245	240	236	230	3 2
zone 2 Temp. (deg c)	245	280	250	250	245	240	286	88	300
zone 3 Temp. (deg c)	245	280	250	250	245	240	256	066	326
zone 4 Temp. (deg c)	245	280	250	250	245	240	3 3	000	922
zone 5 Temp. (deg c)	245	280	250	250	245	96	3: 2	0 1	C77
zone 6 Temp, (deg c)	245	280	250	250	245	240	235	230	225
zone 7 Temp. (deg c)	245	280	250	280	246	3 8	87 8	087	552
8 Connecting Plate Temp (dea C)	346	900	3	3	0.57	747	8	530	225
O Block Town (4-0)	24.5	707	8	750	245	240	238	230	225
And a control of the	245	280	250	250	245	240	235	230	225
10 Spin Pump Temp. (deg.C)	245	280	250	250	245	240	235	230	225
11 Top Cap (deg.C)	245	280	250	250	245	240	235	230	225
12 Spin Pack Temp. (deg.C)	245	280	250	250	245	240	235	230	25
Top Heated Sleeve Length (inches)	xxx	2000	XXX	XXX	XXX	XXX	NO.	1 88	
Top Heated Steeve Temp. (deg. c)	XXX	хоох	XXX	XXX	XXX	XX	XXXX	*****	≸! }
Bottom Heated Steeve Length (Inches)	XXX	XXX))	XXX	XXX	XXX	280		; {: } : }
Bottom Heated Sleeve Temp. (deg. c)	xxxx	xxx	3000	XXX	XXX	XX	- 1000	, X	{ :}
Barrel Melt Temp. (deg. c)	252	288	256	257	251	246	240	235	{ 2
Melt Pump Infet Preseure (psi)	2222	420	10	200	5	10	10	=	<u> </u>
Melt Pump Outlet Pressure (pst)	uu	200	470	250	250	310	260	98	2 5
Extruder (rpm)	200	200	200	200	200	200	200	300	3 5
Spinneret: no. of holes / Shape	14 R	14 R	14 R	4R	4 H	14.8	8 7	4	2 4
Spinneret: capillary diameter & depth	.024 X 0.072	024 X 0.072	024 X 0 072	024 X 0.072					
Metering pump size (cc/rev)	1.16	1.16	1.18	1.18	1.16	1.16	1.18	1.16	1 16
Metering pump (rpm)	16.7	19.3	19.8	19.8	19.8	19.8	19.7	19.7	7 6
Thruput (lbs/hr)	2.97	2.97	2.97	2.97	2.97	2.97	2.97	2.97	2.97
Filter type	STD SCREEN	EEN	STD SCREEN S	TD SCREEN					
Monomer Exhaust Reading (inches water)	TB0	TBD	TBD	TBD	TBD	1			
Quench air Flow rate (CF/M)	14.2	14.2	14.2	14.2	14.2	14.2	15.5	15.9	0 41
Qench air Temp. (deg. c)	19	19	19	19	61	19	19.3	19.6	197
Quench air Humidity %	40.8	40.8	40.8	40.8	40.8	40.8	39.8	39.5	66
, % Torque	20	25	23	22	8	21	20	24	. 2
Nitrogen in Hoper	3	3	3	ю	6	3	3		; ; :
Need: polymer chips moisture	. Yes .								•
Mond , Emp fall parameter for past ,	,	,				1		,	

Official I.D.	2	2	=	#12	613	7.	#15	#16	714
		BHS 10%	BHS 10%	BHS 10%	BHS 10%	ا ا	BHS 10%		135 10%
POLYMER TYPE	BHS	Lactam	Lactam	Lactam	Lactam		Lactam	135	Lactam
Feeder Setting	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96
water on feeding zone	uo	8	ю	uo	ъ	i	ક	6	
zone 1 Temp. (deg c)	252	252	247	242	737		227	260	260
zone 2 Temp. (deg c)	252	252	247	242	237		227	280	280
zone 3 Temp. (deg c)	252	252	247	242	237		722	280	260
zone 4 Temp. (deg c)	252	252	247	242	782		722	260	260
Zone 5 Temp, (deg c)	262	252	247	Z#3	- 237		22	R	. 580
zone 6 Temp. (deg c)	252	262	247	242	237	Ì	122	280	. 66 . 28
zone 7 Temp. (deg c)	252	252	247	242	237		227	380	260
8 Connecting Plate Temp. (deg. C)	252	252	247	242	237		722	5 80	260
9 Block Temp. (deg.C)	252	252	247	242	752		722	260	280
10 Spin Pump Temp. (deg.C)	252	252	247	242	237	j	722	760	560
11 Top Cap (deg.C)	252	252	247	242	782	232	227	260	260
12 Spin Pack Temp. (deg.C)	252	252	247	242	237	}	227	280	560
Top Heated Sleeve Length (Inches)	xxx	ж))	XXX	XXX		XXXX))	XX
Top Heated Sleeve Temp. (deg. c)	XXX	2000	χοα	XXX	хоох		XXX	XXX	XXX
Bottom Heated Sleeve Length (Inches)	χαα	XXX	xxx	XXX	XXXX		хох	XXX	XXX
Bottom Heated Sleeve Temp. (deg. c)	хоох	XXXX	χοα	XXX	xxx	ļ	ххх	X00	XX
Barrel Melt Temp. (deg. c)	259	260	254	249	245	240	235	270	569
Malt Pump Inlet Preseure (psl)	40	90	250	280	081	ŝ	2	<u>\$</u>	300
Melt Pump Outlet Pressure (pst)	970	520	029	610	740	790	. 2	160	1040
Extruder (rpm)	200	200	200	i	200	200	200	500	200
Spinneret: no. of holes / Shape	14R	14 R	14 R		14 R	14 R	14R	14 R	# R
Spinneret: capitary diameter & depth	.024 X 0.072	.024 X 0.072	.024 X 0.072	6	.024 X 0.072	024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072
Metering pump size (cc/rev)	1.16	1.16	1.16	1.16	1.18	1.18	1.16	1.16	1.16
Metering pump (rpm)	19.7	19.7	19.7		19.7	19.7	9.7	19.7	19.7
Thruput (Ibs/hr)	2.97	2.97	2.97	2.97	2.97	2.97	28	2.97	2.97
Filter type	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREE	STD SCREEN	SCREEN	STD SCREEN	STD SCREEN
Monomer Exhaust Reading (inches water)	TBC	TBD	180	TBD	TBD	160	. 	:-:	
Quench air Flow rate (CFMI)	14.6	14.5	14.6	14.9	i	14.6	14.9	Ì	15.1
Gench air Temp. (deg. c)	19.5	18.9	19.2	19.2	:	-6	19.4		19.2
Quench air Humidity %	38.7	39.3	39.7	41.8	39.7	40.3	39.4		41.1
% Torque	42	22	82	30		ಜ	52		37
Nitrogen in Hoper	3	9	8	3	6		т Ю		က
Need: polymer chips moisture							!		
Need: Free fall samples for FAV, COOH									:
1						i - —	ļ- · !	:	

135 10% 135	Sample I.D.	#18	614	8	#21	77.4	\$ 23	#24	\$25	07#
135 if yi, Lactam			135 10%		135 10%	135 10%	135 10%	135 10%		195 10%
1,02,402 1,094 2,96 2,96 2,96 2,96 1,02,402 1,2,02 1,2,0	POLYMER TYPE		Lactam	135 10% Lactam	Lactum	Lactam	Lactam	Lactam	195	Lactam
1024072 1024072 10724072 1225 1	Feeder Setting	2.96	2.96	2.98	2.98	2.98	2.96	2.96	2.96	2.96
on on on on on on on 256 259 246 240 235 230 225 256 250 246 240 235 230 225 256 250 245 240 235 230 225 256 250 245 240 235 230 225 256 250 245 240 235 230 225 256 250 245 240 235 230 225 256 250 245 240 235 230 225 256 250 245 240 235 230 225 256 250 246 240 235 230 225 256 250 246 240 235 230 225 256 250 246 240 235 230 225 256 250	Date	10/24/02	10/24/02	10/24/02	10/24/02	10/24/02	10/24/02	10/24/02	10/24/02	10/24/02
256 250 246 240 236 230 225 255 250 245 240 235 230 225 256 250 246 240 235 230 225 256 250 246 240 235 230 225 256 250 245 240 235 230 225 256 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 246 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 256 250 245 240 235 230 225 256 250	water on feeding zone	8	8	ક	6		8	5		6
255 250 246 240 236 230 225 256 250 246 240 235 230 225 256 250 246 240 235 230 225 256 250 246 240 235 230 225 256 250 245 240 235 230 225 256 250 245 240 235 230 225 256 250 246 240 235 230 225 256 250 246 240 236 230 225 255 250 246 240 236 230 225 256 250 246 240 236 230 225 256 250 246 240 236 230 225 256 250 246 240 236 230 225 260 260	zone 1 Temp. (deg c)	255	250	245	240		230	225	ļ	290/273
255 - 250 - 245 - 246 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 255 - 250 - 245 - 240 - 235 - 230 - 225 - 250 - 250 - 245 - 240 - 235 - 230 - 230 - 250 - <	zone 2 Temp. (deg c)	255	250	245	240		230	225	}	290
256 246 240 235 250 275 256 250 246 240 235 230 225 256 250 245 240 235 230 225 256 250 245 240 235 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 235 230 225 255 250 245 240 236 230 226 250 250 250	zone 3 Temp: (deg c)	255	250	245	240		230	225	:	290
295 246 240 235 220 225 256 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 226 255 250 245 240 236 230 226 255 250 245 240 236 230 226 250 250 245 240 236 230 226 250 250 245	zone 4 Temp. (deg c)	255	250	245	240	ļ	230	225	!	280
255 250 245 240 235 230 225 256 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 236 230 225 256 250 245 240 236 230 225 256 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 246 236 230 226 226 250 250 253 246 230 230 230 264 239 253 248 243 238 236 236 236 236	zone 5 Temp. (deg c)	255	250	246	240		230	228		530
255 250 245 240 235 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 236 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 246 240 235 230 225 255 240 235 230 226 226 226 250 250 246 240 235 230 225 225 226 226 226 226 226 226 226 226 226 226 226 226 226 226 226 226 226 226<	zone 8 Temp. (deg c)	255	250	245	240	;	230	225		290
255 260 245 240 235 230 225 256 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 250 245 240 235 230 225 255 240 235 230 225 230 225 250 250 240 235 230 225 230 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250 250	zone 7 Temp. (deg c)	255	250	245	240		230	225	1	290
255 250 245 240 236 220 225 256 250 245 240 235 230 226 256 250 245 240 235 230 226 255 250 245 240 235 230 226 255 250 245 240 235 220 226 250 250 245 240 235 226 226 250 250 250 250 250 226 226 264 259 253 248 243 238 232 264 259 253 248 243 238 236 260 250 253 248 243 238 236 260 260 260 800 800 100 100 148 144 R 14 R 14 R 14 R 14 R 148 148 R 14	8 Connecting Plate Temp. (deg. C)	255	250	245	240		230	225	•	290
256 260 245 240 236 230 226 256 250 246 240 236 230 226 255 250 245 240 236 230 226 255 250 245 240 236 226 226 250 250 246 256 230 225 226 200 200 200 200 200 200 200 204 259 253 248 243 238 232 204 259 253 248 243 238 230 200 200 200 630 600 680 180 1080 1140 1280 1280 130 100 100 1080 1140 1280 1280 130 200 200 200 1080 140 148 148 148 148 148 1	9 Block Temp. (deg.C)	255	250	245	240		230	225		290
256 250 245 240 236 227 228 232 <td>10 Spin Pump Temp. (deg.C)</td> <td>255</td> <td>250</td> <td>245</td> <td>240</td> <td></td> <td>230</td> <td>225</td> <td>1</td> <td>290</td>	10 Spin Pump Temp. (deg.C)	255	250	245	240		230	225	1	290
255 250 246 240 235 225 225 xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx xxxx <t< td=""><td>11 Top Cap (deg.C)</td><td>255</td><td>250</td><td>245</td><td>240</td><td>ļ</td><td>230</td><td>226</td><td>í</td><td>290</td></t<>	11 Top Cap (deg.C)	255	250	245	240	ļ	230	226	í	290
χοαχ <t< td=""><td>12 Spin Pack Temp. (deg.C)</td><td>255</td><td>250</td><td>245</td><td>240</td><td></td><td>230</td><td>225</td><td>i</td><td>290</td></t<>	12 Spin Pack Temp. (deg.C)	255	250	245	240		230	225	i	290
χοας <t< td=""><td>Top Heated Sleeve Length (Inches)</td><td>XXX</td><td>XXX</td><td>XXX</td><td>χοα</td><td></td><td>XXX</td><td>XXX</td><td>!</td><td>XXX</td></t<>	Top Heated Sleeve Length (Inches)	XXX	XXX	XXX	χοα		XXX	XXX	!	XXX
xxxxx xxxxxx xxxxxx xxxxxx xxxxxx xxxxxx xxxxxx	Top Heated Steeve Temp. (deg. c)	XXX	χοα	XX	2000		χοα	×××××××××××××××××××××××××××××××××××××××	!	XXX
XXXX XXXXX XXXXX XXXXX XXXXXX XXXXXX XXXXXX XXXXXXX XXXXXXX XXXXXXX XXXXXXXXX XXXXXXXXXX XXXXXXXXXX XXXXXXXXXXXXX XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX	ottom Heated Sleeve Length (Inches)	XXX	XXX	хоох	XXX		XXX	XXX	•	XXX
264 259 253 248 243 238 232 630 470 450 630 600 580 190 1080 1140 1280 1280 1330 1480 1700 200 200 200 200 200 200 200 200 2024 X 0.072 0.24 X 0.07	Bottom Heated Sleeve Temp. (deg. c)	хоох	XXX	XXX	XXX		XXX	XXX	•	χοα
630 470 450 630 600 580 190 1080 1140 1260 1280 1330 1480 1700 200 200 200 200 200 200 200 14R 14R 14R 14R 14R 14R 14R 15A 1.16	Barrel Melt Temp. (deg. c)	284	259	253	248		238	232		. 588
1080 1140 1280 1330 1480 1700 200 200 200 200 200 200 200 201 202 200 200 200 200 200 2024 X 0.072 .024 X 0.0	Mett Pump Inlet Pressure (psl)	630	470	450	630		580	061	- 1	1080
200 <td>Mett Pump Outlet Pressure (psl)</td> <td>1080</td> <td>1140</td> <td>1260</td> <td>1280</td> <td></td> <td>1480</td> <td>1700</td> <td></td> <td>790</td>	Mett Pump Outlet Pressure (psl)	1080	1140	1260	1280		1480	1700		790
14 R <th< td=""><td>Extruder (rpm)</td><td>200</td><td>200</td><td>200</td><td>200</td><td></td><td>82</td><td>280</td><td>:</td><td>8</td></th<>	Extruder (rpm)	200	200	200	200		82	280	:	8
024 X 0.072 .024 X 0.072 </td <td>Spinnerst: no. of holes / Shape</td> <td>14 R</td> <td>14R</td> <td>14 R</td> <td>14 R</td> <td></td> <td>7</td> <td>7</td> <td></td> <td>4</td>	Spinnerst: no. of holes / Shape	14 R	14R	14 R	14 R		7	7		4
1.16 1.16	Spinneret: capitary diameter & depth	.024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072	2	.024 X 0.072	.024 X 0.072	0	.024 X 0.072
19.7 2.97 2.97	Metaring pump size (coirey)	1.16	1.16	1.18	1.18		1.18	1.18		1 18
2.97 <th< td=""><td>Metering pump (rpm)</td><td>19.7</td><td>19.7</td><td>19.7</td><td>19.7</td><td></td><td>19.7</td><td>19.7</td><td></td><td>19.7</td></th<>	Metering pump (rpm)	19.7	19.7	19.7	19.7		19.7	19.7		19.7
STD SCREEN STD SCR	Thruput (Ibs/hr)	2.97	2.97	-	2.97	2.97	2.97	2.97	i	2.97
TBD <td>Filter type</td> <td>STD SCR</td> <td>STD SCREEN</td> <td></td> <td>STD SCREEN</td> <td>STD SCREEN</td> <td>STD SCREEN</td> <td>STD SCREEN</td> <td></td> <td>STD SCREE!</td>	Filter type	STD SCR	STD SCREEN		STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN		STD SCREE!
15.2 14.9 14.5 14.4 14.9 14 14.2 20.1 19.5 18.7 19 18.9 19.1 18.7 39.4 40.7 39.7 40.1 41.3 38.7 39.1 39 38 40 37 39 40 42 3 3 3 3 3 3 3 3	nomer Exhaust Reading (inches water)	_	TBD	180	TB0		OH.			
20.1 18.5 18.7 18 18.9 19.1 18.7 38.4 40.7 39.7 40.1 41.3 38.7 39.1 39 38 40 37 39 40 42 3 3 3 3 3 3 3 3	Quench air Flow rate (CF/N)		14.9	14.5	14.4	14.9	14	14.2	14.6	14.8
39,4 40.7 39,7 40,1 41,3 38,7 39,1 39 38 40 37 39 40 42 3 3 3 3 3 3 3 3	Qench air Temp. (deg. c)	20.1	19.5	18.7	19	18.9	19.1	18.7	18.9	19.5
39 38 40 37 39 40 42 3 3 3 3 3 3 3	Quench air Humidity %	39.4	40.7	39.7	40.1	41.3	38.7	39.1	8.96	39.1
3 3 3	% Torque	39	38	04	37	38	04	42	52	38
	Nitrogen in Hoper	3	3	3	၉	3	ല	Ю	6	m
And fell summing for EAV AAM!	Need: polymer chips moisture									٠
LOCO LANGUAGE SECTION OF THE PROPERTY OF THE P	Need : Free fall semples for FAV. COOH									·

Sample I.D.	F4.		4.20	2
		195 10%		195 10%
POLYMER TYPE	195 10% Lactam	Lactam	195 10% Lactem	Lactam
Feeder Setting	2.96	2.96	2.96	2.96
Date	10/24/02	10/24/02	10/24/02	10/24/02
water on feeding zone	6	6	ક	é
zone 1 Temp. (deg c)	0.27582	280/288	275/263	270/258
zone 2 Temp. (deg c)	285	280	275	270
zone 3 Temp. (deg c)	285	280	275	270
zone 4 Temp. (deg c)	285	280	275	270
zone 5 Temp. (deg c)	285	280	275	270
zone 6 Temp. (deg c)	285	280	275	270
ZONE 7 Temp. (deg c)	285	280	275	270
8 Connecting Plate Temp. (deg. C)	285	280	275	270
9 Block Temp. (deg.C)	285	280	275	270
10 Spin Pump Temp. (deg.C)	285	280	275	270
11 Top Cap (deg.C)	285	280	275	270
12 Spin Pack Temp. (deg.C)	285	280	275	270
Top Heated Sleeve Length (Inches)	χοοα	XXX	XXX	XXX
Top Heated Steeve Temp. (deg. c)	χχ	XXX	xxx	XXX
Bottom Heated Sieeve Length (Inches)	XXX	χοα	χα	XXX
Bottom Heated Sleeve Temp. (deg. c)	χοοα	XXX	χοα	XXX
Barrel Melt Temp. (deg. c)	298	289	284	279
Melt Pump Intet Pressure (psl)	1250	တ္	960	1060
Melt Pump Outlet Pressure (psl)	098	890	026	1100
Extruder (rpm)	200	200	200	200
Spinneret: no. of holes / Shape	14 R	14 R	14R	14 R
Spinneret: capitary dlameter & depth	.024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072
Metering pump size (cc/rev)	1.18	1.18	1.16	1.18
Metering pump (rpm)	19.7	19.7	19.7	19.7
Thruput (lbs/hr)	2.97	2.97	2.97	2.97
Filter type	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN
Monomer Exhaust Reading (inches water)	uado	uedo	uado	oben
Quench air Flow rate (CF/M)	14.7	14.7	14.2	13.9
Qench air Temp. (deg. c)	19.2	19.7	50	18.7
Quench air Humidity %	46.1	41.5	43.1	39.4
% Torque	41	28	37	14
Nitrogen In Hoper	3	9	က	60
Need: polymer chips moisture				